



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4034-041
Job Sheet 188201



Part No: D4034-041

Job Qty: 2 pcs

Part Name: Aft Upper Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 1/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA
10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER
DWG REV,pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	1/18/19	1/18/19	0.00	0.00	Start Up Large Fab-6		
100	Large Fab - Basket - 1	2 pcs	1/18/19	1/18/19	0.00	2.30	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 9	2 pcs	1/18/19	1/18/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	2 pcs	1/18/19	1/18/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		

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				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
130	Packaging 3-1 - Stock - B4B 2 pcs	1/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA 2 pcs	1/18/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	

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18-20

FEB 25 2019

Part Op **100** - (Weld per dwg A/R S.S. rod Batch: _____) 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld
 Descriptions: bushing in rib and grind weld flush as per dwg
110 - (QC9- Inspect visual per QSI004- Fusion Welds)
120 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____) LOCATION: WA004
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-7 ✓	Hoop	62 pcs (1 ea) ✓	90-Start up Operation	5150 285
D4021-9 ✓	Bushing	248 pcs (4 ea) ✓	90-Start up Operation	5115 312
D4034-1 ✓	Rib	62 pcs (1 ea) ✓	90-Start up Operation	5154 567
D4034-3 ✓	Rib	62 pcs (1 ea) ✓	90-Start up Operation	5155 031

Master Unit 00 8225

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4021-7	2	18	0
	D4021-9	8	319	0
	D4034-1	2	17	0
	D4034-3	2	13	0
Part Specifications				
Specifications could not be found.				

Plex 1/22/19 8:20 AM Dart.Hadley.Shannon



Container No: S155775



Part: D4034 - 041

Job No: 188201

Serial No/Batch: S155775

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/22/19



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Description:

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Bill of Materials

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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	1/18/19	1/18/19	0.00	0.00	Start Up Large Fab-6		
100	Large Fab	2 pcs	1/18/19	1/18/19	0.00	2.30	Large Fab 1		
110	QC	2 pcs	1/18/19	1/18/19	0.00	0.00	QC9		
120	QC	2 pcs	1/18/19	1/18/19	0.00	0.00	QC5		
130	Packaging	2 pcs	1/18/19	1/18/19	0.00	0.00	Packaging3 Large Fab		
140	QC21-SA	2 Ea	1/18/19	1/18/19	0.00	0.00	QC21		

Part Op 100 - 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld bushing in rib and grind weld flush as per dwg
Descriptions: 130 - LOCATION: WA004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-7	Hoop	2 pcs (1 ea)	90-Start up Operation	
D4021-9	Bushing	8 pcs (4 ea)	90-Start up Operation	
D4034-1	Rib	2 pcs (1 ea)	90-Start up Operation	
D4034-3	Rib	2 pcs (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4021-7	2	15	0
	D4021-9	8	415	0
	D4034-1	2	12	0
	D4034-3	2	8	0

Part Specifications

Specifications could not be found.

Plex 1/4/19 11:28 AM Dart.lajeunesse.marie

LFC

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					